

Date: Monday, 11/19/2007 4:05:09 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CABIN FLOOR PROTECTOR
Job Number	: 35865		
Estimate Number	: 12765		
P.O. Number	: N/A	Part Number	: D35744
This Issue	: 11/19/2007 S.O. No. : N/A	Drawing Number	: D3574 REV.A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 33397	Material	: N/A
Written By	:	Due Date	: 12/5/2007 Qty: 3 Um: Each
Checked & Approved By	: <u>7/11/20</u>		
Comment	: Est Rev: A New Issue 07-01-22 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	F60029	lexan grey
-----	--------	------------



Comment: Qty.: 32.0000 sf(s)/Unit Total : 96.0000 sf(s)
F60029 lexan sheet
Batch: 105330 18 07-11-22

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
1-Cut as per Dwg D3574
Dwg Rev: A
Prog Rev: A

18 07-11-22

③

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

18 07-11-22

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

6 11/12/23 ④

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

9 SAD 07-11-25 ⑤

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: DD Date: 5/14/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/19/2007 4:05:09 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN FLOOR PROTECTOR

Job Number: 35865

Part Number: D35744

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 7/11/26 (13)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: 35818

FINAL INSPECTION/W/O RELEASE

AS 7/11/27 (13)

8.0

QC21



Comment: FINAL INSPECTION/W/O RELEASE

(3) 7/11/27

Job Completion



W 7/11/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

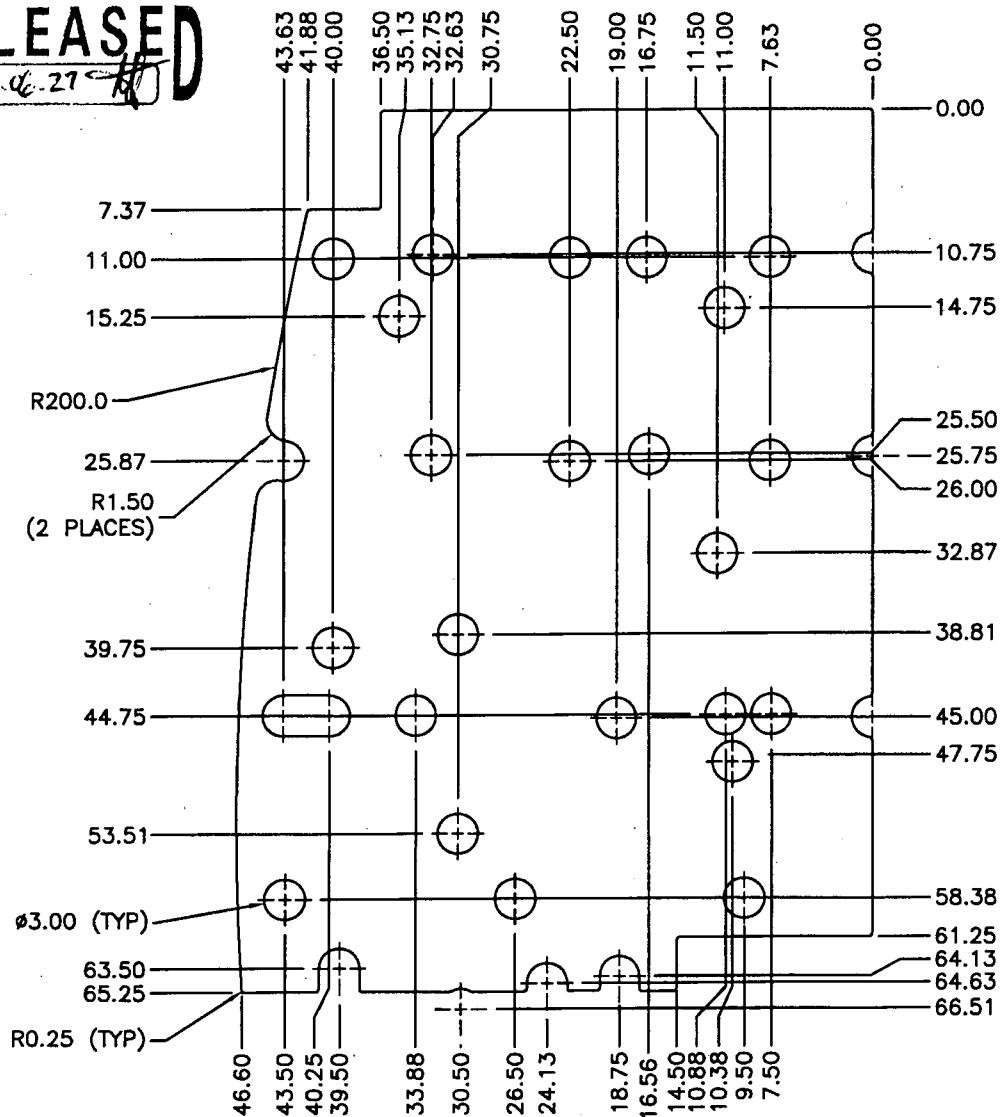
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

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CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3574	REV. A SHEET 1 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14
A	07.06.08	NEW ISSUE	

RELEASED
07-06-27**D3574-1 CABIN FLOOR PROTECTOR (SHOWN). D3574-2 (OPPOSITE)****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-1/-2" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8961

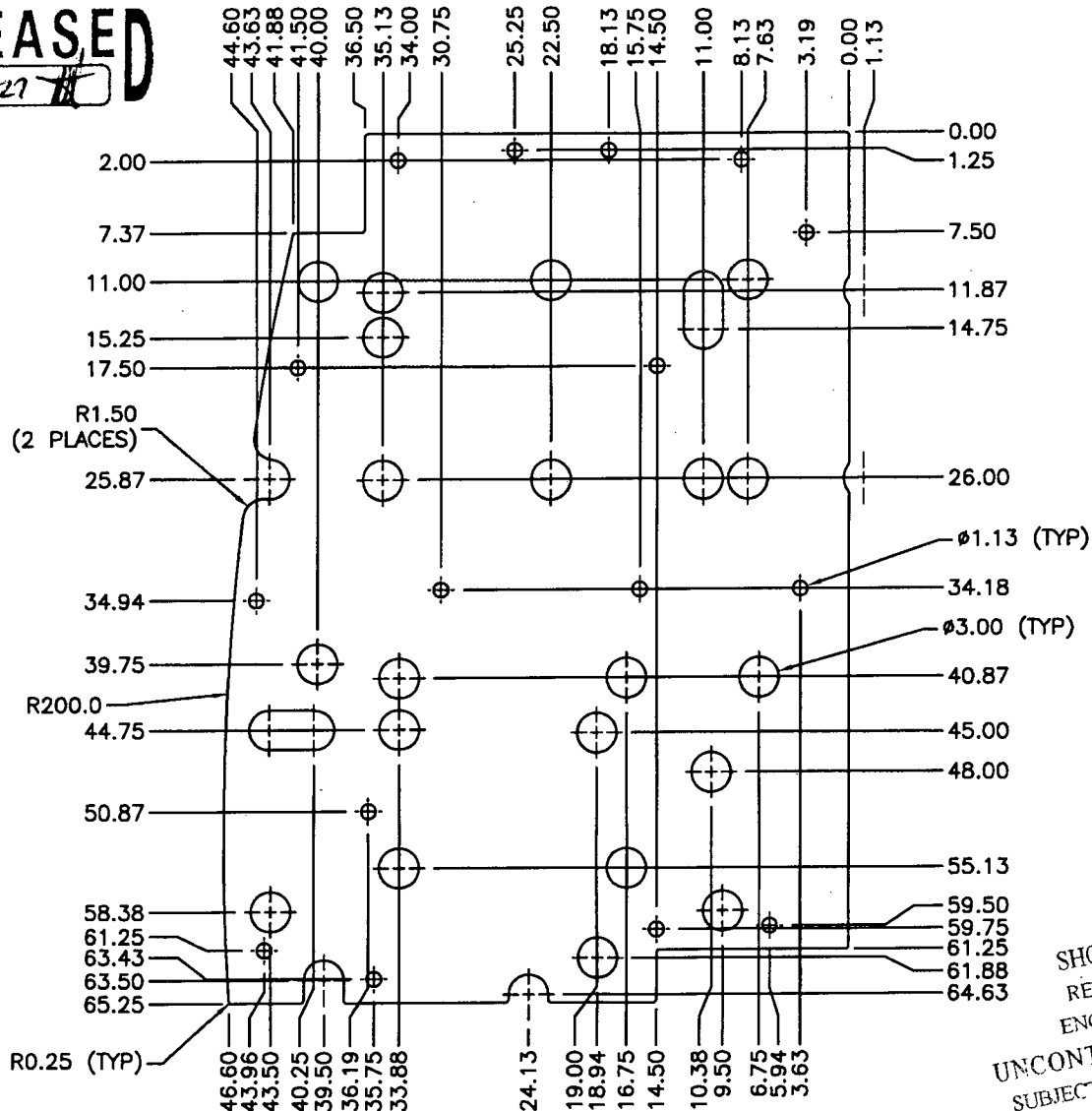
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DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

RELEASED
07.06.27**D3574-3 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-3" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8962

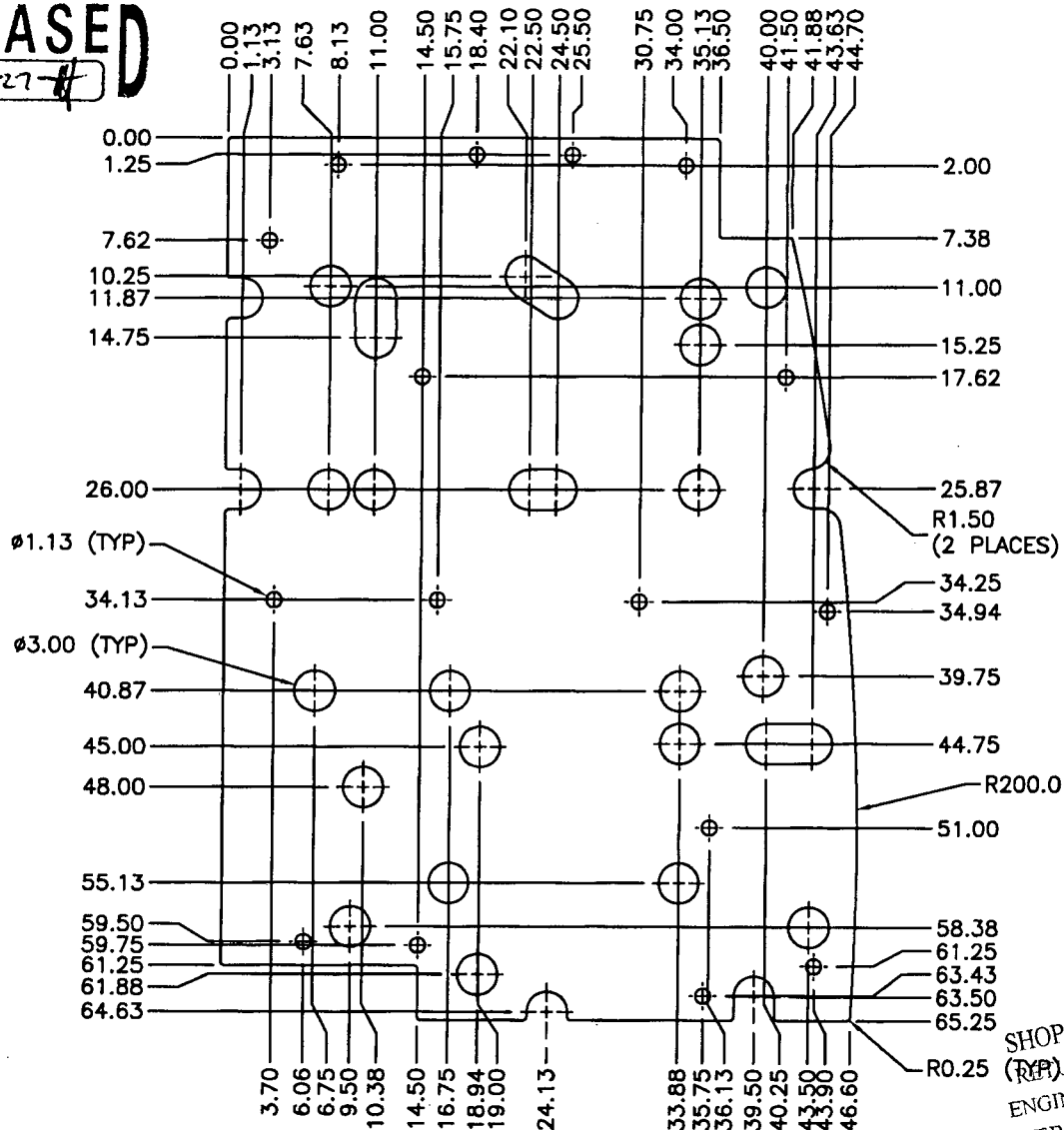
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DATE 07.06.08	TITLE CABIN FLOOR PROTECTOR		SCALE 1:14

RELEASED
07.06.27-#**D3574-4 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-4" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8963

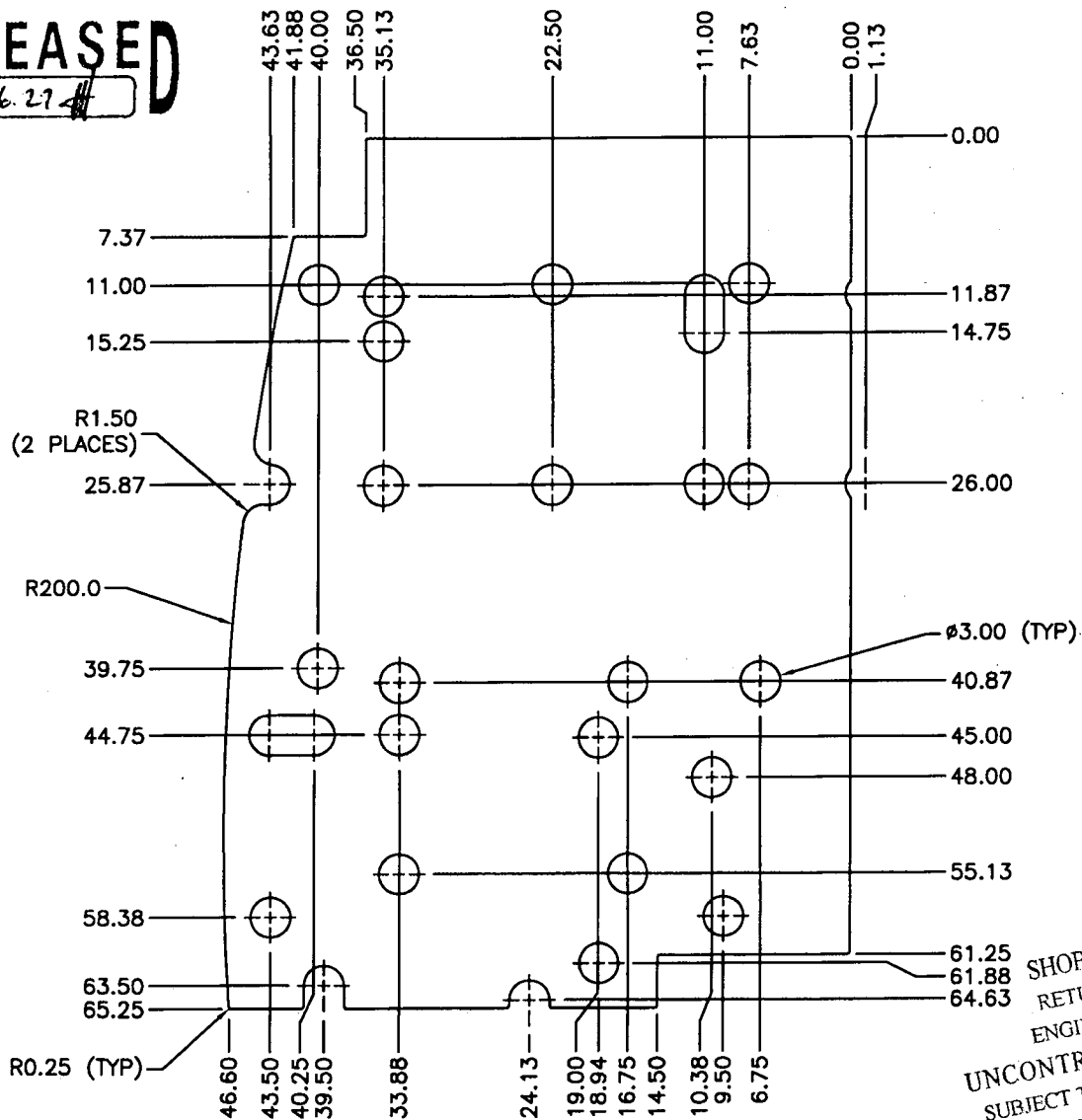
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DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

RELEASED
07.06.27**D3574-5 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-5" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8964

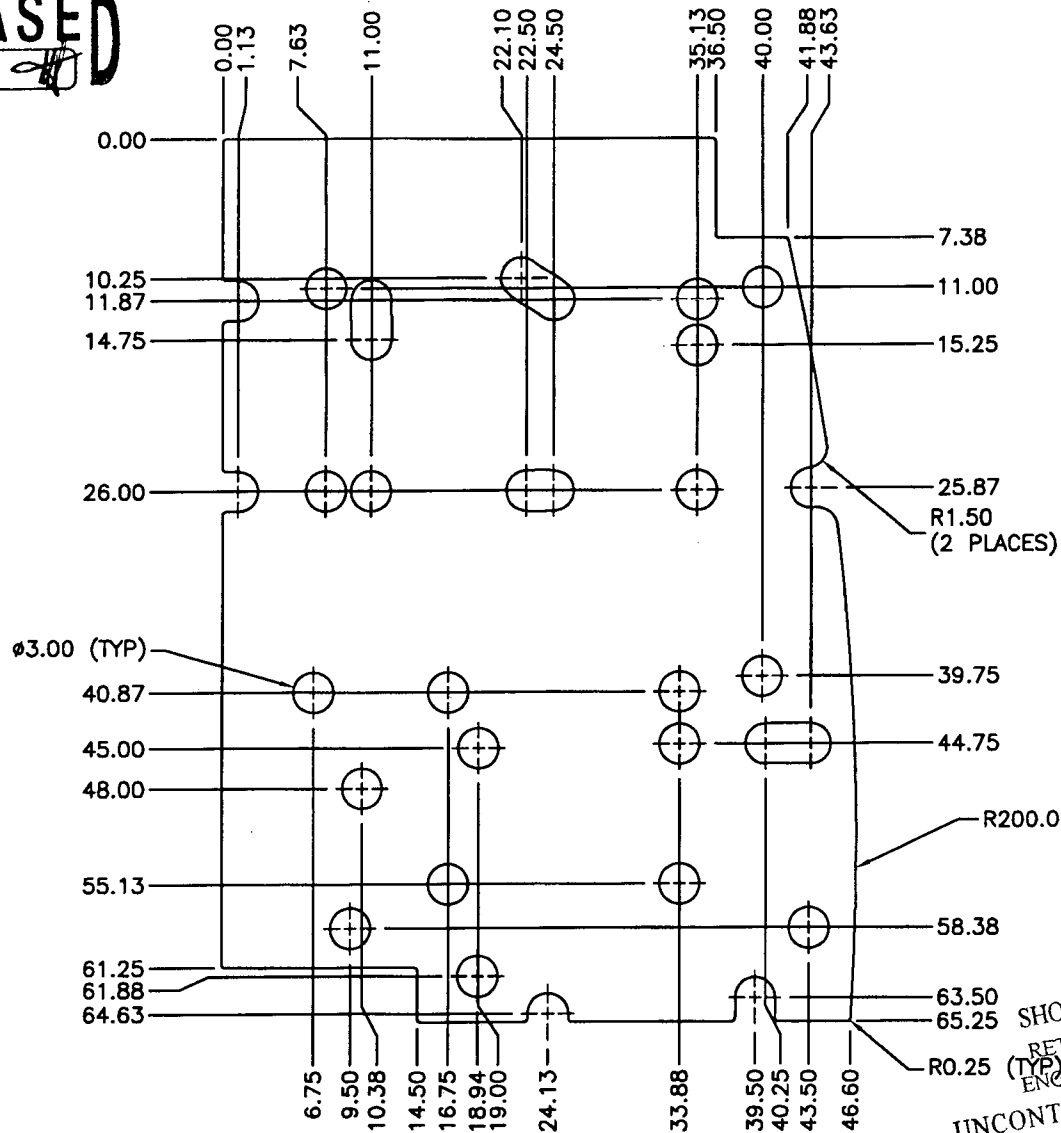
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DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

RELEASED
07.06.27**D3574-6 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-6" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8965

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DART AEROSPACE LTD		Work Order:	35865
Description: CABIN FLOOR PROTECTOR		Part Number:	D3574-4
Inspection Dwg: D3574-4 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.70	+/- .030	3.70	✓			
6.06	+/- .030	6.06	✓			
6.75	+/- .030	6.75	x			
9.50	+/- .030	9.50	✓			
10.38	+/- .030	10.38	x			
14.50	+/- .030	14.50	x			
16.75	+/- .030	16.75				
18.94	+/- .030	18.94				
19.00	+/- .030	19.00				
24.13	+/- .030	24.13				
33.88	+/- .030	33.88				
35.75	+/- .030	35.75				
36.13	+/- .030	36.13				
39.50	+/- .030	39.50				
40.25	+/- .030	40.25				
43.50	+/- .030	43.50				
43.90	+/- .030	43.90				
46.60	+/- .030	46.60				

Measured by:	IB
Date:	07-11-22

Audited by:	[Signature]
Date:	07/11/23

Prototype Approval:	[Signature]
Date:	1/9

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

[Signature]

DART AEROSPACE LTD		Work Order:	35865
Description: CABIN FLOOR PROTECTOR		Part Number:	D3574-4
Inspection Dwg: D3574-4 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.13	+/- .030	1.13	x			
3.13	+/- .030	3.13	x			
7.63	+/- .030	7.63	x			
8.13	+/- .030	8.13	x			
11.00	+/- .030	11.00	x			
14.50	+/- .030	14.50	x			
15.75	+/- .030	15.75	x			
18.40	+/- .030	18.40	x			
22.10	+/- .030	22.10	x			
22.50	+/- .030	22.50	x			
24.50	+/- .030	24.50	x			
25.50	+/- .030	25.50	x			
30.75	+/- .030	30.75	x			
34.00	+/- .030	34.00	x			
35.13	+/- .030	35.13	x			
36.50	+/- .030	36.50	x			
40.00	+/- .030	40.00	x			
41.50	+/- .030	41.50	x			
41.88	+/- .030	41.88	x			
43.63	+/- .030	43.63	x			
44.70	+/- .030	44.70	x			

Measured by: IB	Audited by: J	Prototype Approval: /
Date: 07-11-22	Date: 7/16/23	Date: 7/16/23

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

[Handwritten signature]